

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008866**Date Inspected:** 24-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Yu Min, Chen Ying Xin	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No	N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No	N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No	N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No	N/A
		Delayed / Cancelled:	Yes No	N/A
Bridge No:	34-0006	Component:	Tower and OBG Components	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

OBG Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following work in progress in the trial assembly area:

5AW/5BW, between panel points 31 and 32 – match drilling through 5BW deck panel U-ribs into inner doubler plates only on the two extreme north and south.

1AAW – FCAW welding after UT indication and excavation of 8th from south end I-rib to deck plate weld joint. Welder was identified as 220063. ZPMC QC was identified as CWI Xu Yu Min (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Pan Wen Long, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-345-FCAW-4G(4F)-repair.

4AW, panel point 25, west side and panel point 28, west side – spray painting in the deck panel diaphragm area.

4AW, panel point 26, west side – sandblasting in the deck panel diaphragm area.

Bay 10

WELDING INSPECTION REPORT

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This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 10:

FCAW welding of weld joint SSTL3-1B/K-85B located on PCMK south tower shaft, lift 3. Welders were identified as 052075, 050041. ZPMC QC was identified as CWI Chen Ying Xin (QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2232-Tc-U5b-F.

SMAW base metal repair welding located in various locations on PCMK south tower shaft, lift 3, skin D. Welder was identified as 040491. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-345-SMAW-3G(3F)-repair. Also at this location and appearing to be monitoring the welding and recording data was ABF Representative Li Nan.

ZPMC personnel rigged north tower shaft, lift 1 onto six Scherle flatbed transports and removed the shaft from Bay 10.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above, and this QA Inspector, George Goulet, asked each QC monitoring the welding if all the welding variables observed by QC appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector, George Goulet, that QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all QC observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
